

Date: Wednesday, 11/06/2008 2:25:16 PM
User: Julie Lecocq

Process Sheet

Split w/o
SS 08/06/12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR ARM
Job Number : 39823	
Estimate Number : 10335	
P.O. Number :	Part Number : D2010104
This Issue : 11/06/2008 S.O. No. :	Drawing Number : D2010 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : PRELIM
Previous Run : 39681	Material :
Written By :	Due Date : 23/06/2008 Qty: 50 Um: Each
Checked & Approved By : <i>JUL 08-06-11</i>	
Comment : Est A 04.02.17 New issue KJ/JLM	
Est Rev:B 08-05-27 as per ECN1195P DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 78.7500 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall

(M304TR0500W049)

Batch No: *1108215*

SS 08/06/13 (43)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727

Identify as D2010-104

FF 08-06-19 (43)

SS 08/06/13 (43)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-104T2

2- Deburr ends

-D E 08/06/13

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Plug

batch: *B39661 x 10 / B39826 x 33*

FF 08-06-16 43

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- flare before installing plug as per dwg D2010

FF 08-06-16 43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/06/2008 2:25:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39823

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Install D2057 plug as per Dwg D2010

FF 08-06-16 43

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

508/06/16 (x43)

7.0

POWDER COATING

POWDER COATING



M102316



(43x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:20
320 OF
1:50

m.f 08/06/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(43x)

Comment: INSPECT POWDER COAT

8/6/23

SD

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(43x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 228

8/6/23

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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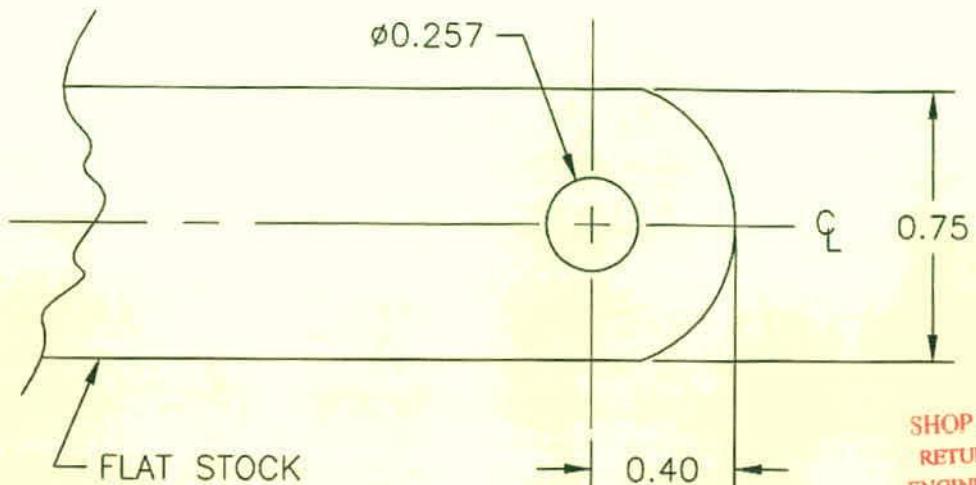
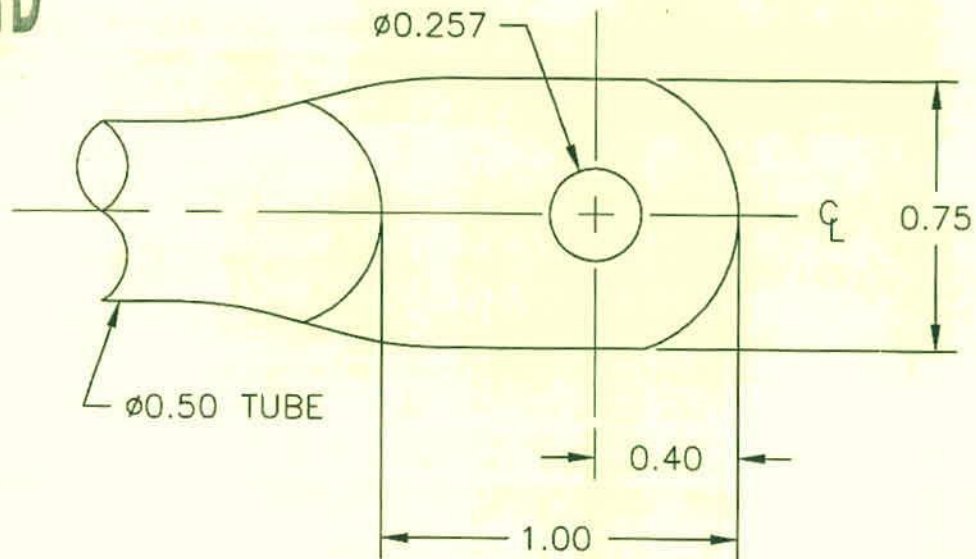
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#1P 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries